

**Work Order ID 69092**

Page 1

Friday, April 29, 2011 8:54:07 AM

Item ID: D3208-7

Accept



Setup Start



Revision ID:

Item Name: Filler

Stop



Start Date: 4/29/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:



Date: 1104-29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3208	Rev A1

100  

SHEAR

Shear

Memo

0.00

SB 1104-102

Shear

Cut blank: 2.750" x 4.300" □ Identify for D3208-7

110  

Small Fab

Small Fab

Memo

0.00

SB 1104-102

Drill and Fillet D3208-7 corner as per Dwg D3208 □ Identify as D3208-7

120  

NC BRAKE

Brake NC

Memo

0.00

Brake NC

Deburr D3208-7 □ Polish any marks on part within 01. of Dwg D3208

SB 1104-102

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 69092**

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Page 2

Item ID: D3208-7

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Revision ID:

Item Name: Filler

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Start Date: 4/29/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC5- Inspect part completeness to step on W/O

0.00

8 wostor

(x2)

QC

Quality Control

140



Chemical Conversion Coat per QSI005 4.1

0.00

2 4/11/05/03

HandFinish

Hand Finishing

150



QC3- Inspect Part Finish

0.00

QC

Quality Control

0.00

2 BK 11-5-3

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Page 3

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Accept



Setup Start



Revision ID:

Item Name: Filler

Stop



Start Date: 4/29/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 5/3/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location: 202

0.00

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/3 SF (2)

11/6/4 JJ

11/11-05-3  
(2)

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**Picklist Print**

Friday, April 29, 2011 8:54:14 AM

Page 1

Work Order ID: 69092



Parent Item: D3208-7



Parent Item Name: Filler

Start Date: 4/29/2011

Required Date: 5/3/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP: B 04.05.25 Material changed for Step 4 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	83.5000	0.0902	0.189895		SB 11/05/02	

2024-T3 .040 sheet



Location	Loc Qty	Loc Code
MAT022	83.5	
112291	0.5	
112331	19	
113162	64	200

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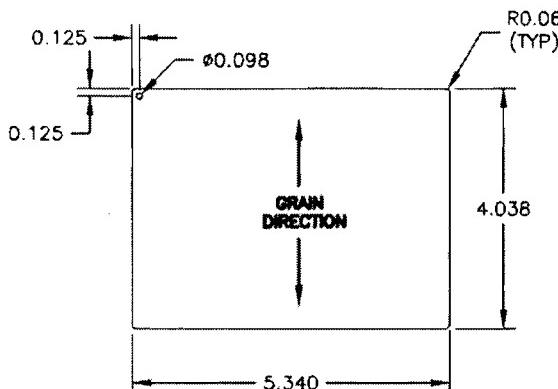


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DATE  
04.01.27

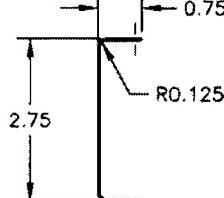
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04.04.05 *[initials]*

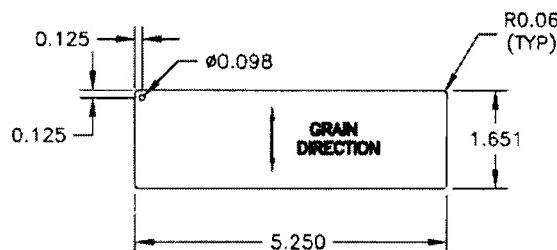
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AI | # 14 04.05.25 | EXPIRED DATES, NOTE 3) 14.04.05



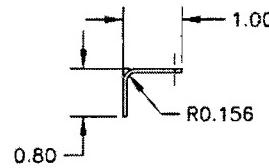
**D3208-1 DOUBLER  
FLAT PATTERN**



**D3208-1 DOUBLER  
BEND DETAIL**



**D3208-3 PEDAL MOUNT ANGLE  
FLAT PATTERN**



**D3208-3 PEDAL MOUNT ANGLE  
BEND DETAIL**

SHOP COPY

RETURN TO

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 69092

*PL1104-29*

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

*AA*

*(3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)*

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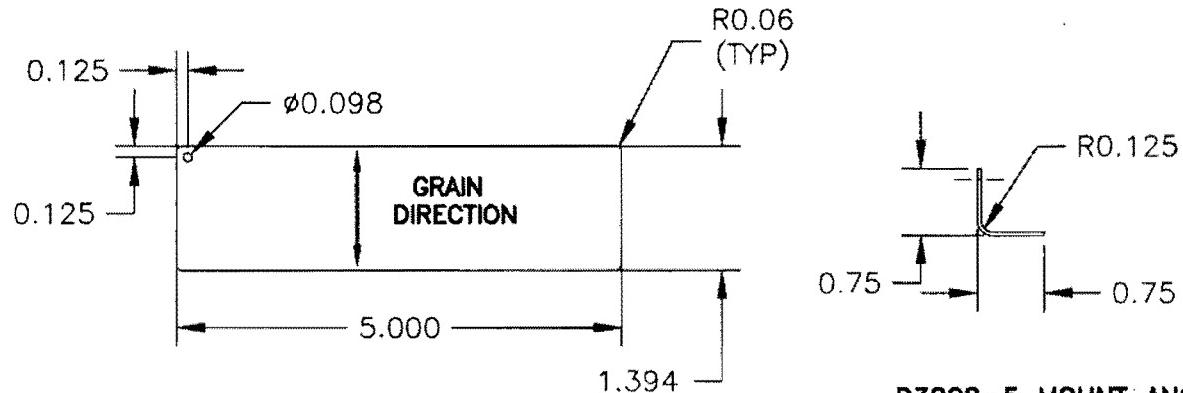
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DATE 04.01.27	TITLE DOUBLER	SCALE 1:2

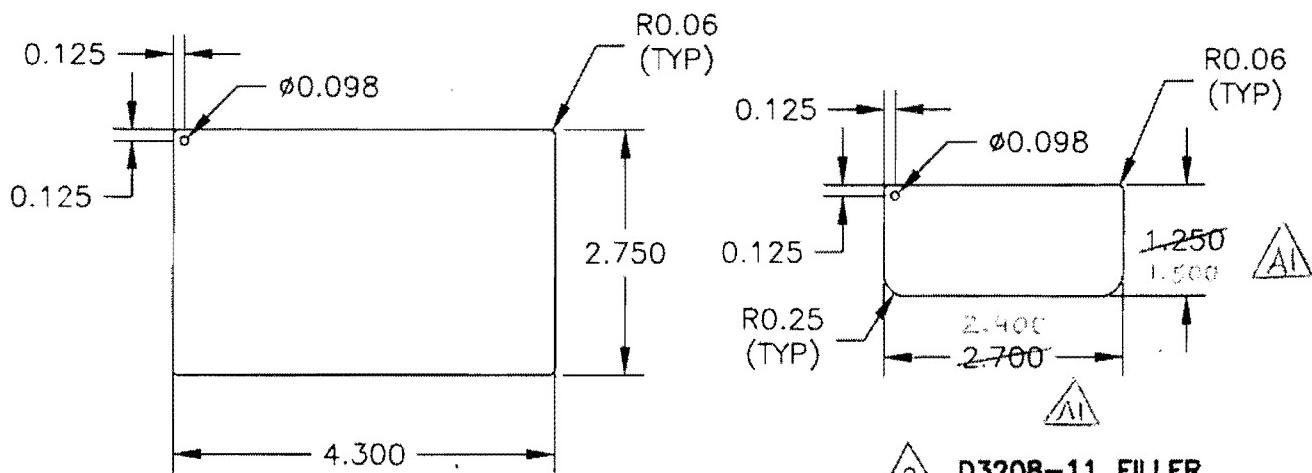
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04.04.05 #



D3208-5 MOUNT ANGLE  
BEND DETAIL



D3208-5 MOUNT ANGLE  
FLAT PATTERN



D3208-11 FILLER



D3208-7 FILLER

w/0 69092

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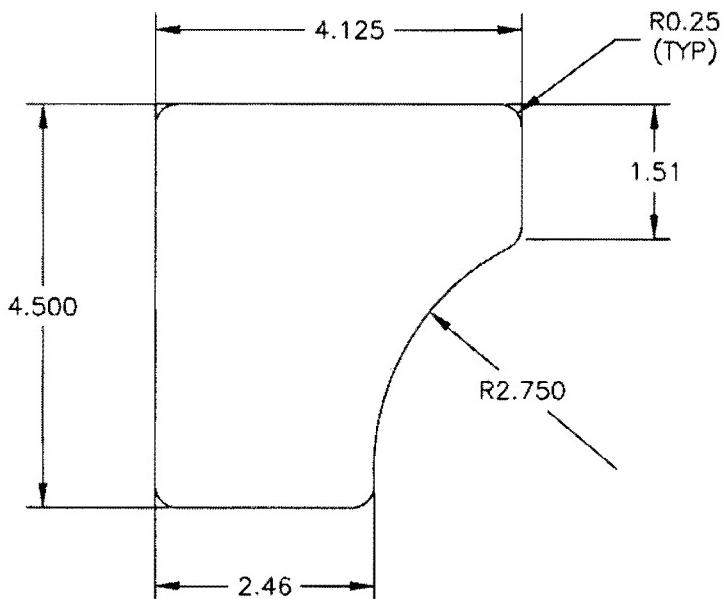
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DATE 04.01.27		TITLE DOUBLER	SCALE 1:2	

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D3208-9 DOUBLER

wb 69092

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